

Work Order ID 60026

Tuesday, June 22, 2010 3:25:38 PM



Page 1

Item ID: D4047-043

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 6/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

HL

Date: *10622*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4047	A

100 Weld per dwg A/R S.S. rod Batch: *M108175* 0.00



Large Fab

Memo

0.00

- 1- Cut D4047-3 as per dwg D4047
- 2- Drill and chamfer holes as per dwg D4047
- 3- Remove identification markings
- 4- Weld bushing in rib and grind weld flush as per dwg D4047

SAO 10-06-23

DPD 10.06.23

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

S. 10.06.23

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID:	D4047-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly				Stop	
Start Date:	6/22/2010	Start Qty:	2.00			
Required Date:	7/30/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u> Memo	0.00 0.00					PD 10.06.23		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/06/24 PR/10-6-24

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Picklist Print

Tuesday, June 22, 2010 3:25:41 PM

Page 1

Work Order ID: 60026

Parent Item: D4047-043

Parent Item Name: Rib Assembly





Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10/01/06 verified by:EC IPP Rev:B as per
dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9  Bushing		Manufactured	No			100	Each	24.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				24					
				56094				2					
				58701				6					
				59838				16					
M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	446.7945	1.9633	4.133263			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				146.7944919					
				113763				0					
				114323				28.3020789					
				114677				14.34201					
				114835				104.150403					
				MAT017				3.68448E-05					
				114298				3.6845E-05					
				WA				300					
				114992				300					



10.06.23

4



SAD 10-06-23

4.133263

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

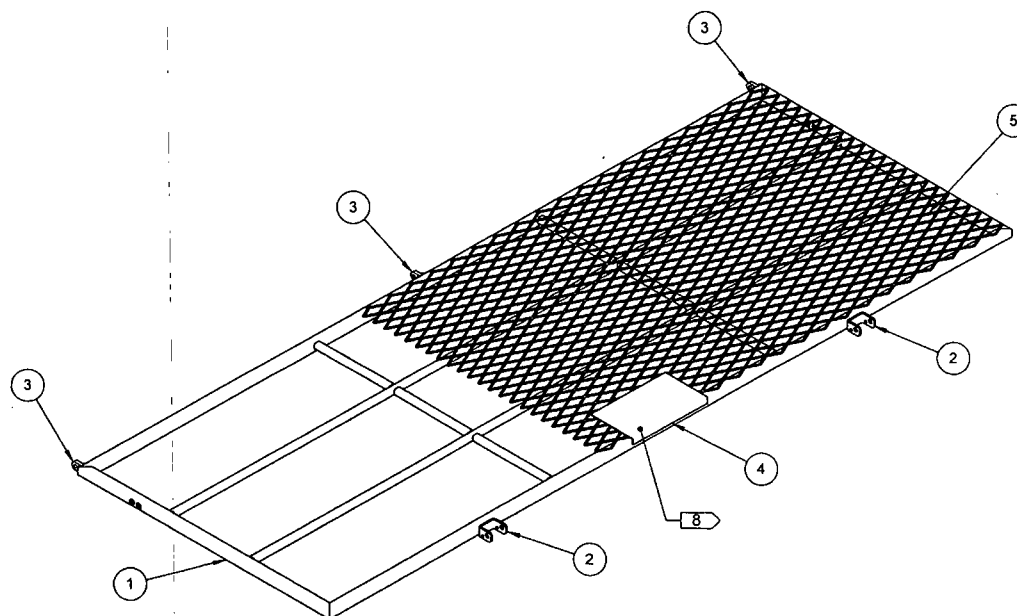
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4047-041	SHORT BASKET LID ASSY
1	1	D4047-101	LID FRAME ASSY
2	2	D2581	MOUNTING BRACKET
3	3	D4016-3	HINGE HALF, LID
4	1	D4021-3	LABEL PLATE
5	1	D4046-7	MESH



D4047-041 SHORT BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.17 lbs APROX
- 8) APPL BLACK ANTI-SKID PAINT TO TOP SURFACE OF MESH, EXCEPT ON D4021-3 LABEL PLATE PER DART QSI 005 4.4

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *66024*
10-6-22

RELEASED
R 2010-02-16
MD

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>RS</i>		
MFG. APPR.	<i>MS</i>		
APPROVED	<i>MS</i>		
DE APPR.	<i>MS</i>		
DATE	10.01.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4047** REV. A
TITLE **SHORT BASKET LID ASSY** SCALE NTS
SHEET 1 OF 6

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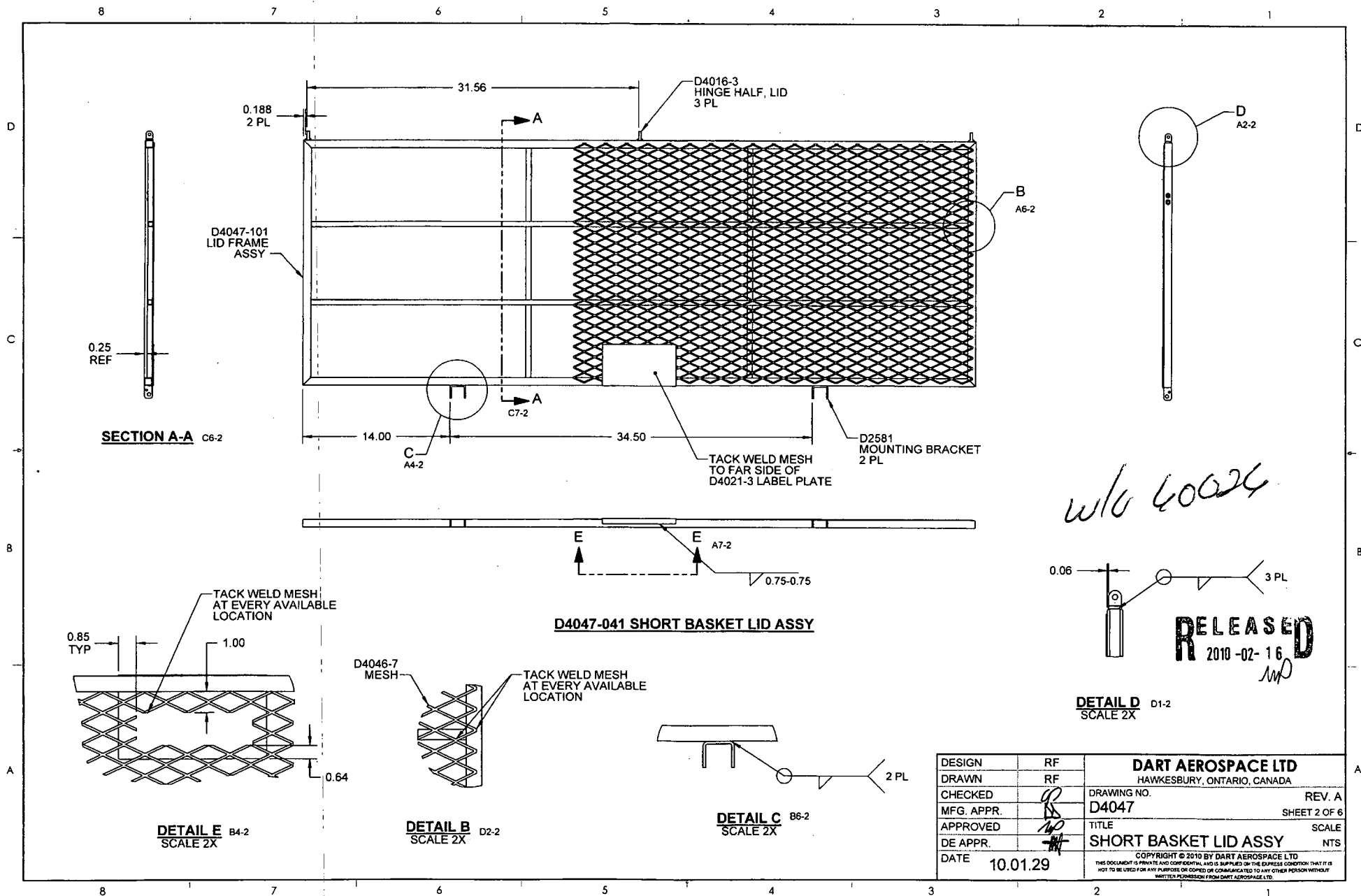
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



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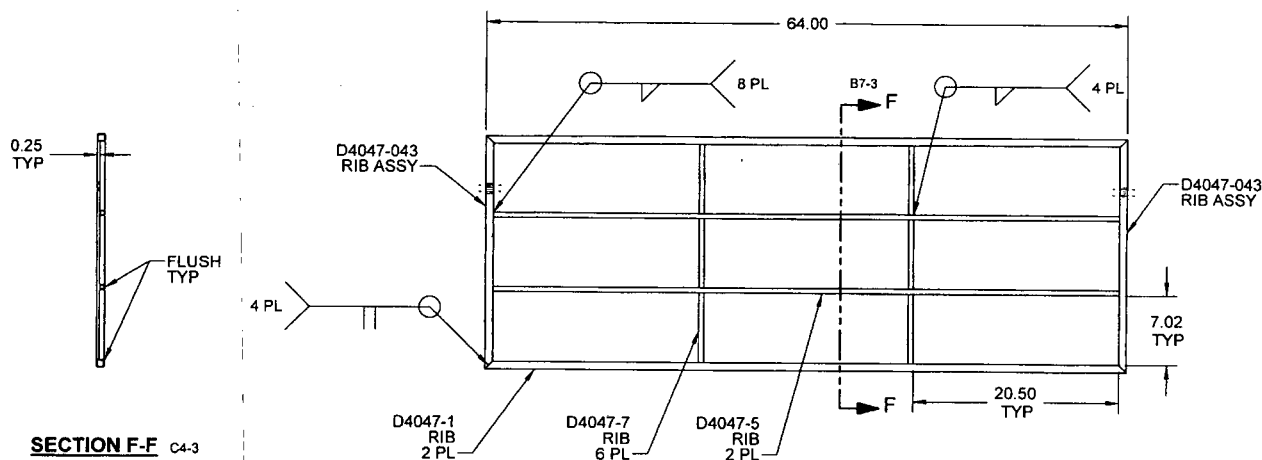
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4047-101	LID FRAME ASSY
1	2	D4047-043	RIB ASSEMBLY
2	2	D4047-1	RIB
3	2	D4047-5	RIB
4	6	D4047-7	RIB



SECTION F-F C4-3

D4047-101 LID FRAME ASSY

wlg 40024

RELEASED
R 2010-02-16
md

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 10.33 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>ss</i>	D4047	SHEET 3 OF 6
APPROVED	<i>sp</i>	TITLE	SCALE
DE APPR.	<i>th</i>	SHORT BASKET LID ASSY	NTS
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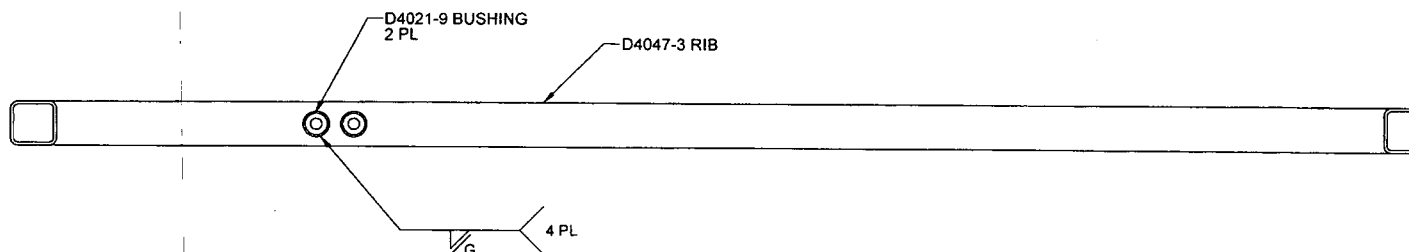
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING



D4047-043 RIB ASSEMBLY

who 60026

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) WELD PER DART QSI 004

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CHECKED	<i>RF</i>	DRAWING NO. D4047	REV. A
MFG. APPR.	<i>MP</i>	TITLE SHORT BASKET LID ASSY	SCALE NTS
APPROVED	<i>MP</i>	DATE 10.01.29	
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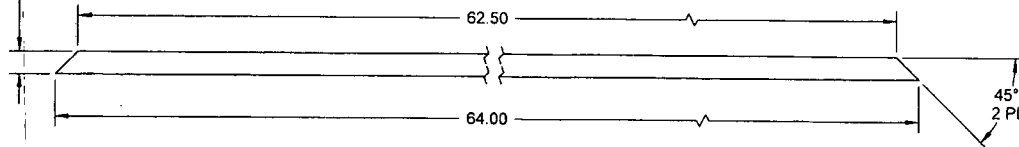
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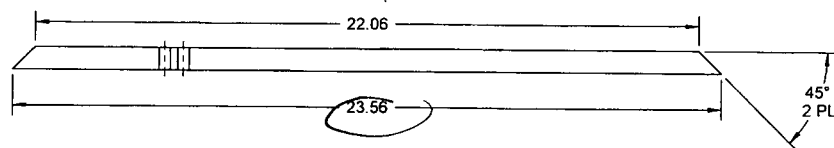
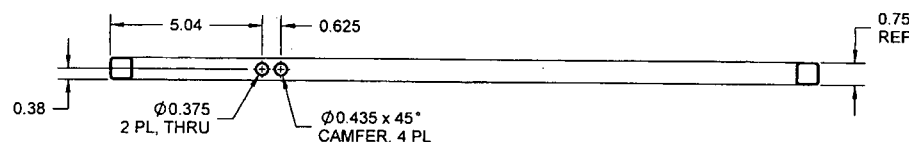
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NOTE: Date & initial all entries

0.75
REF



D4047-1 RIB



D4047-3 RIB

wlb 60026

RELEASED
2010-02-16
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-1: 2.63 lbs
D4047-3: 0.84 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4047	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY	NTS
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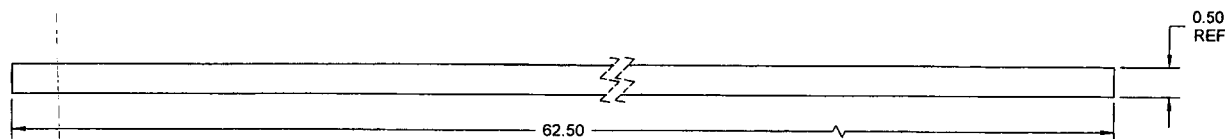
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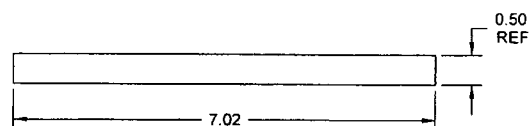
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NOTE: Date & initial all entries



D4047-5 RIB



D4047-7 RIB

w/o 60026

RELEASED
2010-02-16
mp

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-5: 1.44 lbs
D4047-7: 0.16 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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